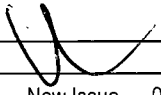
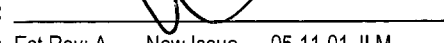


Date: Friday, 25/01/2008 9:06:16 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FUEL SCUPPER ASSEMBLY
<b>Job Number</b> :	36917A01		
<b>Estimate Number</b> :	10151		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32701
<b>This Issue</b> :	25/01/2008	<b>Drawing Number</b> :	D3270 REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	36940A	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	29/02/2008
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	30 / 20 Um: Each
<b>Comment</b> :	Est Rev: A New Issue 05-11-01 JLM Est Rev: B now water jet 08-01-24 DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S040	6061-T6 .040 Sheet
-----	-------------	--------------------



**Comment:** Qty.: 0.0393 sf(s)/Unit Total : 0.7854 sf(s)  
 6061-T6 .040" thick sheet (M6061t6S040)  
 Batch: 105842 B 8-1-28

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3270  
 Dwg Rev: B  
 Prog Rev: B

B 8-1-28

30

2-Deburr if necessary

3.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

B 8-1-28

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

S 08/01/28 (30)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

2-Form D3270-1 and drill holes using D3270-1T1 as per Dwg D3270

FF 08-01-29

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 01/02/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/01/2008 9:06:16 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL SCUPPER ASSEMBLY

Job Number: 36917A01

Part Number: D32701

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/30 (730)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

30  
08/02/01

Job Completion



08/01/31

76.A

~~Backlog~~ ID+stack

8/1/31

50

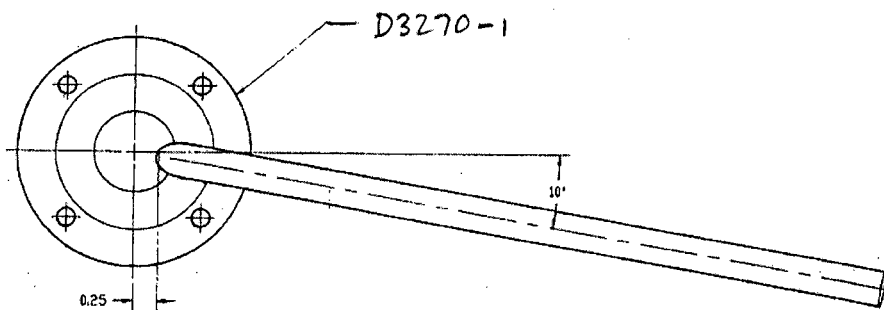
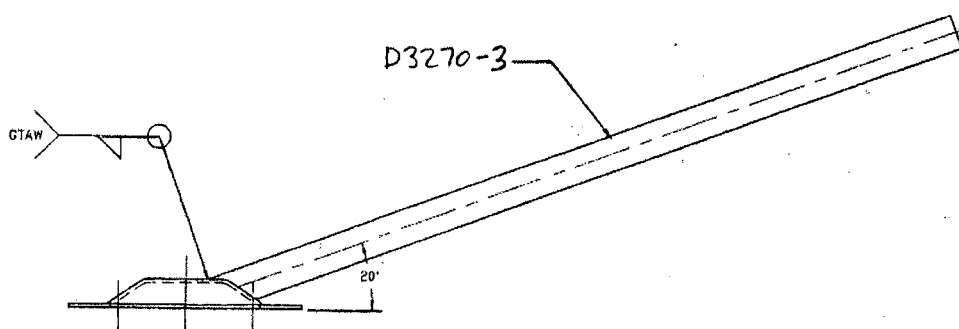
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DESIGN	<i>AA</i>	DRAWN BY	<i>AA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>AA</i>	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE	05.07.14			TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20			NEW ISSUE	
B	<del>05.07.14</del>			ADD D3270-1 FLAT PATTERN	

RELEASED  
04.02.23 *CP*



D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
  - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

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WORK ORDER  
NO. 36917A01

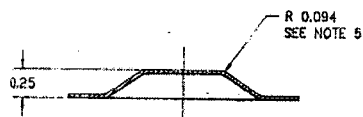
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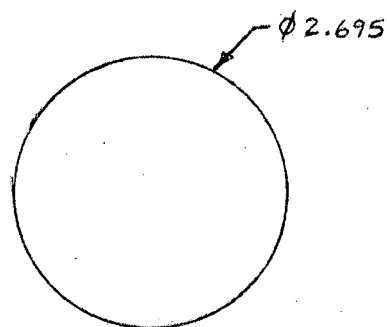
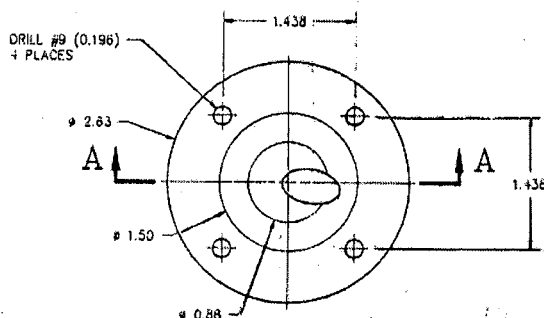


DESIGN	<i>AT</i>	DRAWN BY	<i>AT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CP</i>	APPROVED	<i>AT</i>	DRAWING NO. <b>D3270</b>
DATE	05.07.14	TITLE	FUEL SCUPPER ASSEMBLY	REV. B SHEET 2 OF 2
A	04.02.20	NEW ISSUE		SCALE NTS
B	<del>AT</del> 05.07.14	ADD D3270-1 FLAT PATTERN		

RELEASED  
04.02.23 *AT*



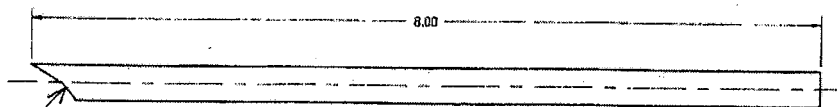
SECTION A-A



D3270-1 FLAT PATTERN

D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT  
D3270-1

D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)  
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8  
(M6061T6T0.375W.035)

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